

**Work Order ID 107517**

Friday, September 27, 2013 9:15:36 AM

*Next*  
*2 week 27 sept*  
**\*107517\***

Page 1

Item ID: D2662-2

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Saddle, RH Fwd, Aft, In

Start Date: 9/27/2013 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 10/11/2013 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *13-9-27*

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2662

Rev E

100

0.00

**\*100\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.  
Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB069 &amp; DWG

DWG REV: *E*FOLIO REV: *AA**6 0 213-10-4*

110

0.00

**\*110\***

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

*6 0 213-10-4*

**\*107517\***

Friday, September 27, 2013 9:15:36 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 9/27/2013      **Start Qty:** 6.00      **\*6\***

**Cust Item ID:**

**Required Date:** 10/11/2013      **Req'd Qty:** 6.00      **\*6\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

0.00

**\*130\***

QC

## Memo

0.00

## Quality Control

0.00

**\*140\***

HandFinish

## Memo

0.00

## Hand Finishing

**\*107517\***

Page 3

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 9/27/2013      **Start Qty:** 6.00      **\*6\***

**Cust Item ID:**

**Required Date:** 10/11/2013      **Req'd Qty:** 6.00      **\*6\***

**Customer:**

**Reference:**

Approvals:      Process Plan:      Date:      Tooling:      Date:

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

## Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*150\***

## Memo

0.00

Powdercoat

START TIME:

OVEN TEMPERATURE:

FINISH TIME: \_\_\_\_\_

160

QC3- Inspect Part Finish

0.00

**\*160\***

## Memo

0.00

QC

## Quality Control

170

Identify as per dwg & Stock Location: 87 432 0.00

**\*170\***

## Memo

0.00

## Packaging

### Packaging

**Work Order ID 107517**

Friday, September 27, 2013 9:15:36 AM

**\*107517\***

Page 4

Item ID: D2662-2

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Saddle, RH Fwd, Aft, In

Start Date: 9/27/2013 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 10/11/2013 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00


**\*180\***

QC

Memo

0.00

Quality Control

 13/10/10ME  
13-10-10

# Picklist Print

Friday, September 27, 2013 9:15:33 AM

Page 1 / 1

Work Order ID: 107517

Parent Item: D2662-2

Parent Item Name: Saddle, RH Fwd, Aft, In

Start Date: 9/27/2013

Required Date: 10/11/2013

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house  
processEC  
ERROR 11-11-17 JLM VERIFIED BY:DD  
IPP Rev:D As per Rev D 07-03-19 JLM

IPP REV:D REDESIGN PER ENG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 Saddle Billet		Manufactured	No			100	Each	30.0000	1	6		SL 13-10-11	

Location

Loc Qty

Loc Code

MAT042

30

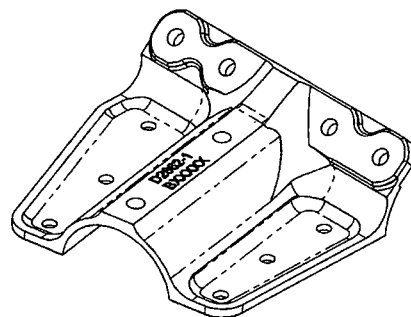
103637

3

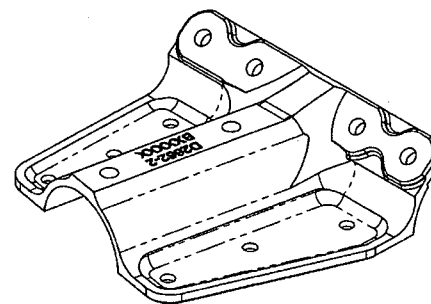
97239

27

6



**D2662-1 SADDLE, INSIDE, LH**



**D2662-2 SADDLE, INSIDE, RH**

*MF*  
*#107517*  
*13-9-27*

**RELEASED**  
 2011-11-16

REV.	DESCRIPTION	BY	DATE
E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
DESIGN		DATE	
DRAWN		DATE	
CHECKED		DATE	
MFG. APPR.		DATE	
APPROVED		DATE	
DE APPR.		DATE	
DATE		DATE	

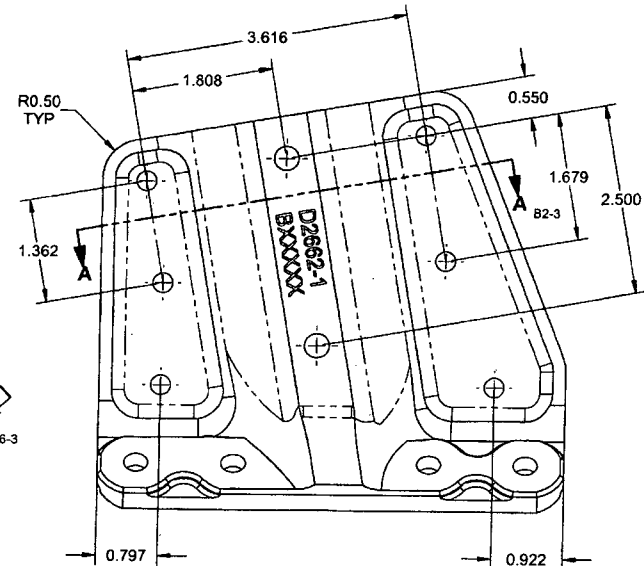
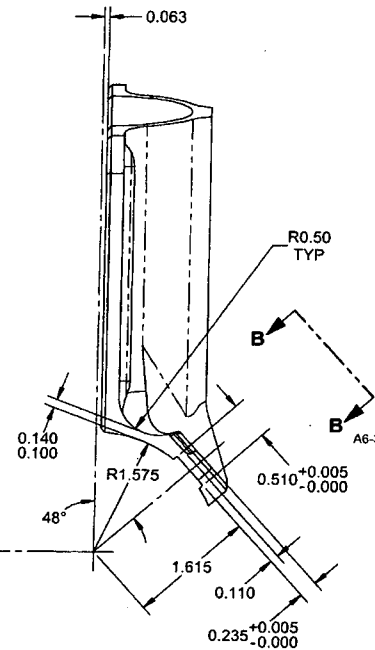
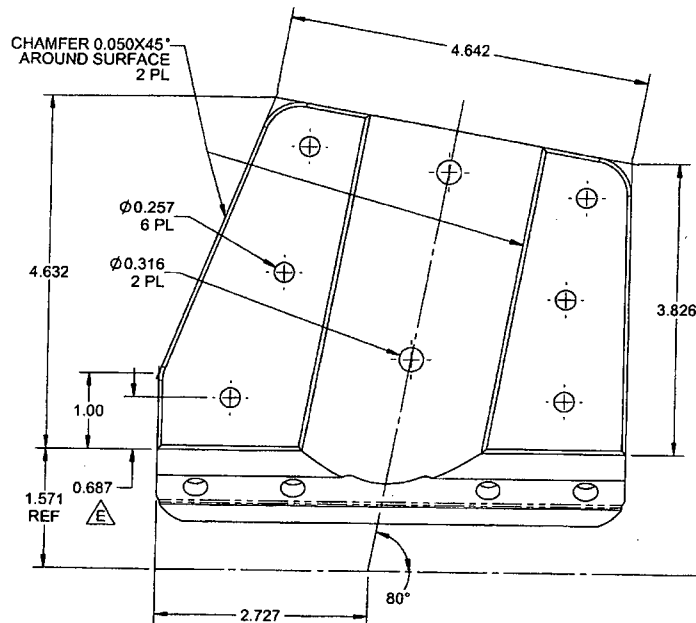
**DART AEROSPACE USA, INC.**  
 KENT, WA

DRAWING NO. **D2662**  
 TITLE **SADDLE, INSIDE**  
 SCALE **NTS**

DATE **11.10.31**

REV. E  
 SHEET 1 OF 5

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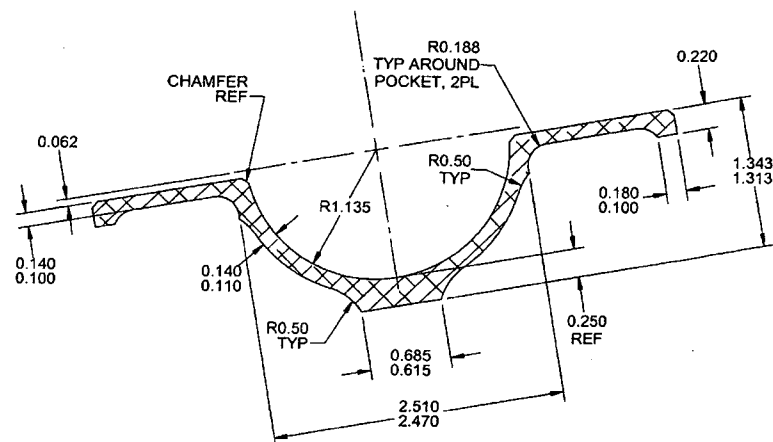
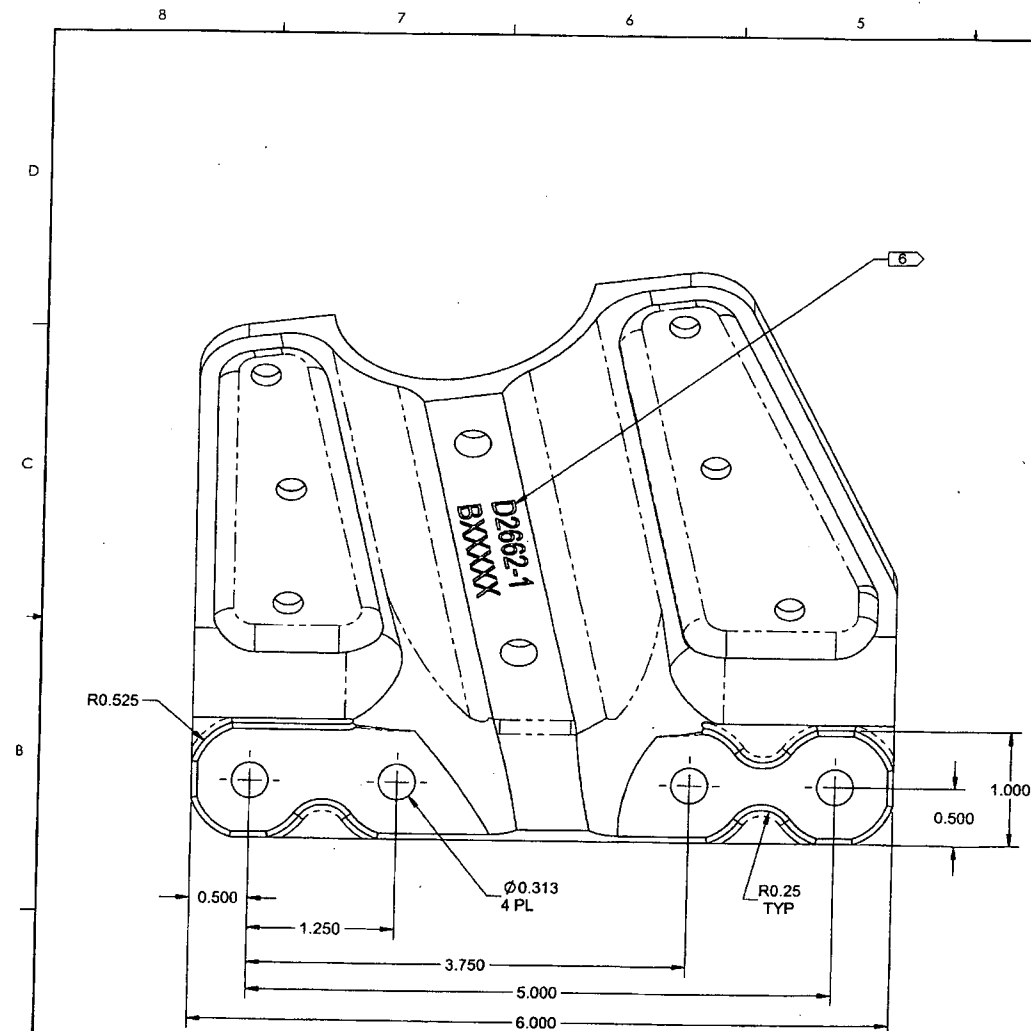


# **D2662-1 SADDLE, INSIDE, LH**

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209  
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. <b>D2662</b>	REV. E
MFG. APPR.		TITLE	SHEET 2 OF 5
APPROVED		<b>SADDLE, INSIDE</b>	SCALE
DE APPR.			NTS
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2011-11-16



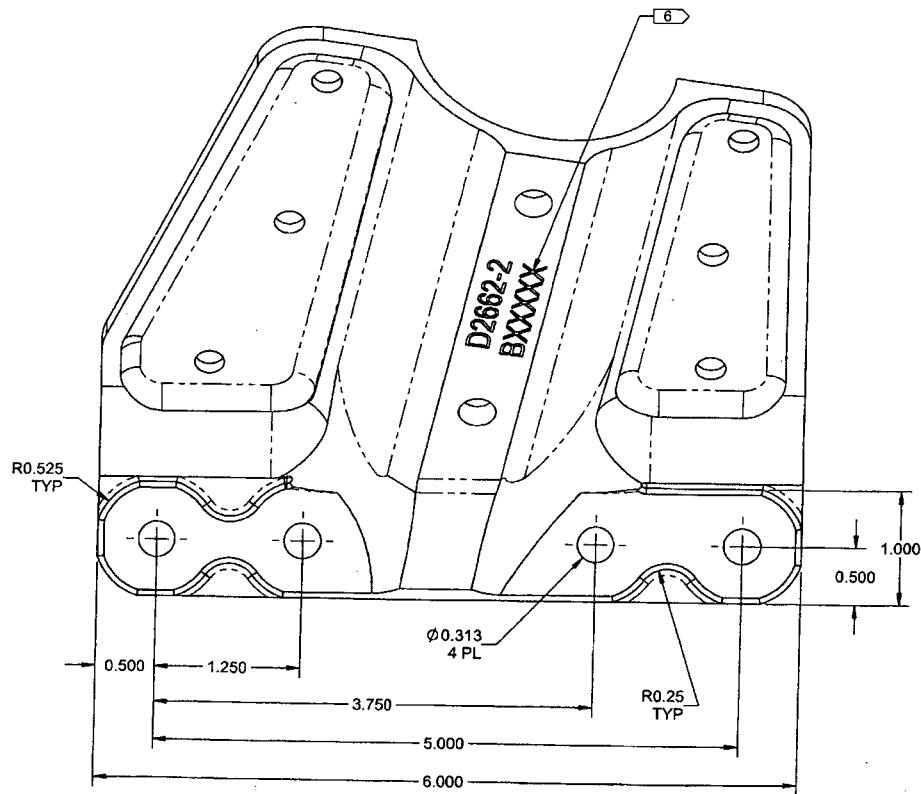
#107517

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2011-11-16

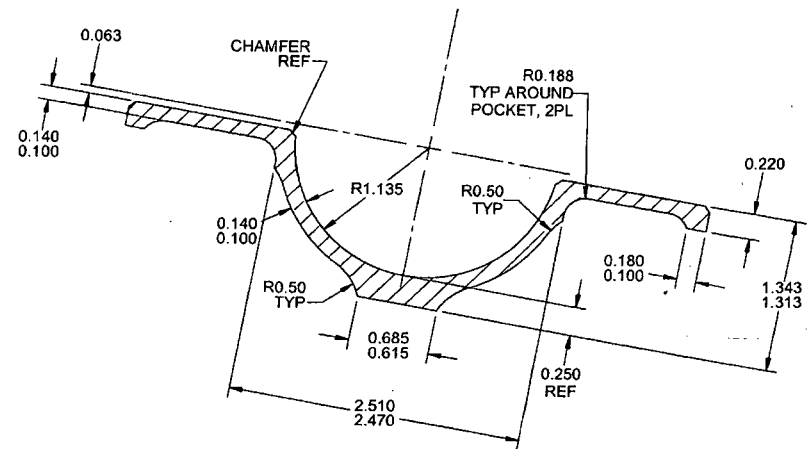
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DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2662	REV. E
MFG. APPR.		TITLE	SHEET 3 OF 5
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**VIEW D-D** B4-4  
SCALE 1.5X  
VIEW ROTATED



**VIEW C-C** C3-4  
SCALE 1.5X

#107517

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2011-11-16

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CHECKED		DRAWING NO. <b>D2662</b>	REV. E
MFG. APPR.		TITLE	SHEET 5 OF 5
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DE APPR.			NTS
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> #109517	
<b>Description:</b> 206 Saddle, Inboard, Left side		<b>Part Number:</b> D2662-2	
<b>Inspection Dwg:</b> D2662 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions					
				1	2	3	4	5	6
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		-258	-258	-258	-258	-258	-258
C	0.315	0.322		-316	-316	-316	-316	-316	-316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		-119	-119	-119	-118	-119	-117
G	0.210	0.230		-220	-220	-220	-220	-219	-218
H	0.615	0.685		-685	-685	-685	-685	-685	-685
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.325	1.325	1.325	1.325	1.325	1.324
K	0.178	0.198		-188	-188	-188	-188	-188	-188
L	0.470	0.530		-500	-500	-500	-500	-500	-500
M	1.125	1.145		1.138	1.139	1.139	1.139	1.139	1.138
N	0.100	0.180		-140	-140	-140	-140	-140	-140
O	0.100	0.140		-135	-130	-135	-134	-134	-134
P	0.240	0.260		-248	-249	-249	-248	-247	-247
Q	0.677	0.697		-687	-687	-687	-687	-687	-687
R	0.540	0.560		-552	-552	-552	-551	-552	-552
S	0.912	0.932		-922	-923	-923	-923	-922	-922
T	0.787	0.807		-798	-798	-798	-798	-799	-799
U	5.990	6.010		6.002	6.000	6.001	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		-498	-500	-501	-500	-503	-500
X	0.312	0.319		-314	-314	-314	-314	-314	-314
Y	0.990	1.010		-997	-999	-999	-999	-999	-997
Z									
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		-497	-499	-499	-499	-499	-497
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		-135	-134	-134	-135	-135	-134
AE	0.235	0.240		-238	-238	-238	-238	-238	-238
AF	0.510	0.515		-512	-512	-512	-512	-512	-512
AG	0.100	0.120		-115	-115	-113	-113	-113	-113
AH	1.565	1.585		1.578	1.579	1.579	1.579	1.579	1.578
Accept/Reject									

<b>Measured by:</b> <u>SL</u>	<b>Date:</b> <u>13-10-4</u>
<b>Audited by:</b> <u>CMR</u>	<b>Date:</b> <u>13/10/04</u>
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	<u>M</u>